

Work Order ID 86901

86901

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July-09-12 10:34:04 AM

Item ID: D3081-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Hinge
 Start Date: 7/09/12 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 8/03/12 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: P Date: 12-07-10 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3081	Rev A								

100 0.00
 100 Small Fab
 Small Fab Memo 0.00
 Small Fab Cut hinge as per dwg (approx 26 pieces) and drill as per dwg D3081. Debur. Bend hinge as per dwg D3081.

5
 5
 FF 12-09-05
 SB 12/09/05

110 0.00
 110 QC5- Inspect part completeness to step on W/O
 QC Memo 0.00
 Quality Control

SMB 12-9-5
 DAS 16
 12/09/05

5

120 0.00
 120 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum
 Powdercoat Memo 0.00
 Powder Coating Break hinges immediately after powder coat. START TIME:
 8:30 OVEN TEMPERATURE: 9:00 FINISH
 TIME: 320°F

5X
 Mr. F
 12/09/06

M121841

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3081-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Hinge

Start Date: 7/09/12

Start Qty: 4.00

4

Cust Item ID:

Required Date: 8/03/12

Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: 025	0.00							
140									
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

5 0 12-9-61

56/8 12/9/06

12/9/11

mf 12-09-07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Work Order ID: 86901

Parent Item: D3081-1

Parent Item Name: Hinge

Start Date: 7/09/12

Required Date: 8/03/12

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A02.04.26New IssueNG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MS20257-5-7200

Purchased

No

110

Each

160.0000

0.3333

1.3332

⑤ FF12-09-05

Piano Hinge

Location

Loc Qty

Loc Code

ST489A

160

100854

12

101041

30

101334

102

102489

16

1.6665

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

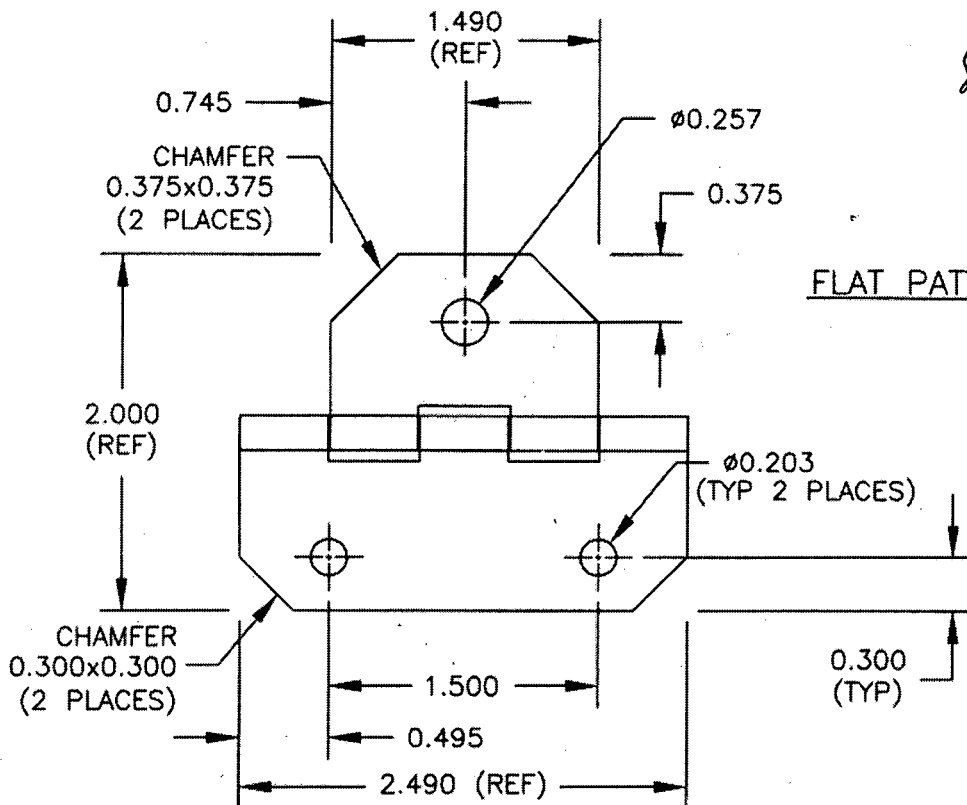
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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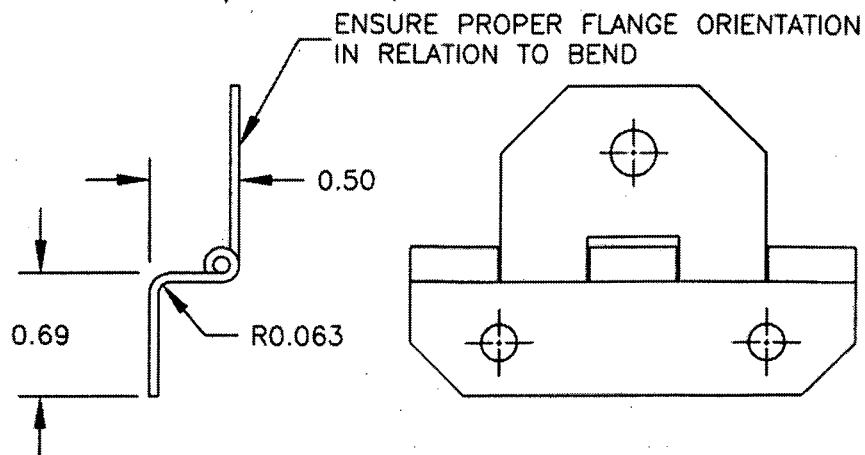


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3081	REV. A SHEET 1 OF 1
DATE 02.01.18		TITLE HINGE	SCALE 1:1
A	02.01.18	NEW ISSUE	



86901
P/D0710
FLAT PATTERN

BENDING DETAIL



D3081-1 HINGE
MAKE FROM MS20257-5 CONTINUOUS HINGE
BREAK SHARP EDGES 0.015 MAX
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

RELEASED
02.01.25 *[Signature]*

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